

Date: Thursday, 04/09/2008 1:23:10 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 41824  
 Estimate Number : 11162  
 P.O. Number :  
 This Issue : 04/09/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : MACHINED PARTS  
 Previous Run : 40639  
 Written By :  
 Checked & Approved By : JLD 08.9.04  
 Comment : Est A04.09.02 New issue KJ/JLM

Drawing Name : BRACKET  
 Part Number : D32641  
 Drawing Number : D3264 REV A  
 Project Number : N/A  
 Drawing Revision : A  
 Material :  
 Due Date : 30/09/2008 Qty: 16 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1250X04500 6061-T6 Bar 1.25 X 4.50



Comment: Qty.: 0.5097 f(s)/Unit Total: 6.1160 f(s)  
 Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick  
 (M6061T6B1.250x04.500)  
 Identify for D3264-1  
 Batch: 110885 = 11 piece mm 08/09/10

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
 Cut blanks: 4.500" x 1.250" x 5.700" long Bar mm 08/09/10

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA447 and Dwg D3264  
 Identify as D3264-1  
 Deburr J.L 08/09/12

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.L 08/09/12

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK J.F. 08/09/12 W19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3264-1 PAR #: N/A Fault Category: Prod / Machined parts NCR: Yes No DQA: D Date: 08/09/12  
 Resolution: Scrap Disposition:  QA: N/C Closed: D Date: 08/22/12

NCR: <u>41824</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/12	3.0	2 parts scrap, due to bearing under tolerance. 1 - .125 is .095. 2 - .125 is .109. 2 parts lifted in the	<u>[Signature]</u>	Scrap: destrat. No replace / No more material.	J.L. 08/09/12	<u>[Signature]</u> 08/09/12	<u>[Signature]</u> 08/09/12	<u>[Signature]</u> 08/09/12
<u>↓</u>	3.0	machine: Not snug enough in the vise. Note: too tight in the vise can buckle the part. Part.	<u>[Signature]</u>		J.L. 08/09/12	<u>[Signature]</u> 08/09/12	<u>[Signature]</u> 08/09/12	<u>[Signature]</u> 08/09/12

NOTE: Date & initial all entries

Date: Thursday, 04/09/2008 1:23:10 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 41824

Part Number: D32641

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

JP

08-09-16

(29)

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING  
Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

M108523

START TIME: 11:30am  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 12:00pm

JP

08-09-16

(29)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2 08/09/16

(9)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Identify with P/N and B/N using a permanent fine point marker, then Stock  
Location: \_\_\_\_\_

08/09/17 (9)

10.0	QC21	FINAL INSPECTION W/O RELEASE
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Comment: FINAL INSPECTION W/O RELEASE

08/09/17

Job Completion



MF 08-09-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41824
<b>Description:</b> Bracket		<b>Part Number:</b> D3264-1
<b>Inspection Dwg:</b> D3264 <b>Rev:</b> A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article    ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	.689	✓			
0.063	+/-0.010	.061	✓			
0.125	+/-0.010	.118	✓			
0.875	+0.010/-0.020	.870	✓			
0.062	+/-0.010	.061	✓			
R0.03	+/-0.030	1.03	✓			
R0.13	+/-0.030	1.125	✓			
1.00	+/-0.030	.997	✓			
0.125	+/-0.010	.123	✓			
0.600	+/-0.010	.600	✓			
4.000	+/-0.005	4.000	✓			
0.750	+/-0.010	.750	✓			
Ø0.194	+0.005/-0.000	.194	✓			
5.50	+/-0.030	5.499	✓			
0.125	+/-0.010	.125	✓			
0.063	+/-0.010	.063	✓			
R0.25	+/-0.030	1.250	✓			
4.27	+/-0.030	4.270	✓			
R0.30	+/-0.030	1.30	✓			

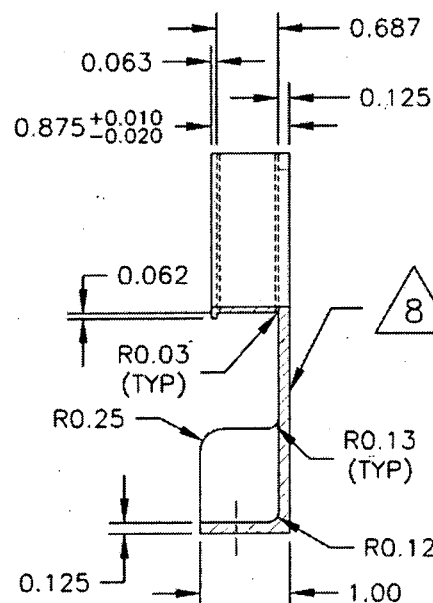
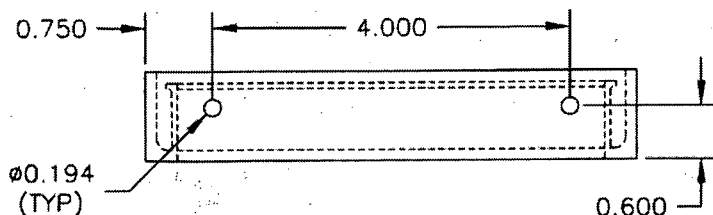
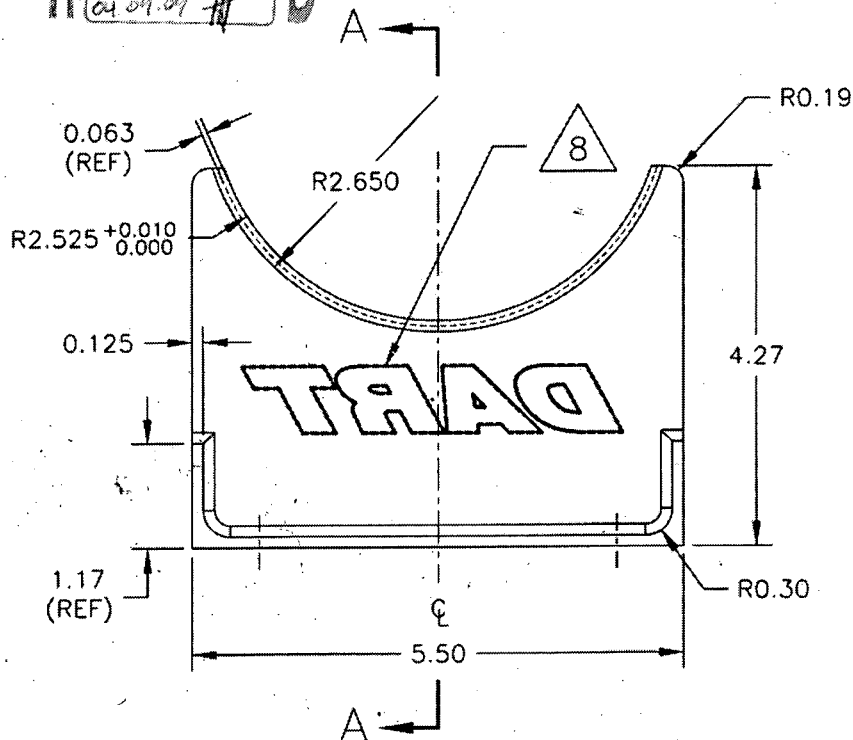
<b>Measured by:</b> J.L.	<b>Audited by:</b> J.F.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08/09/11	<b>Date:</b> 08/09/12	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	

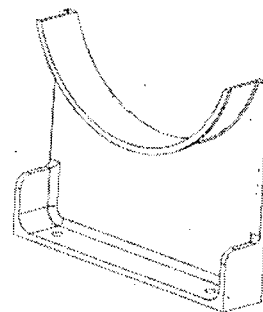
**DART**

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED  
04.04.20 #



**SECTION A-A**



**D3264-1 BRACKET**

**D3264-1:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061 T651)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 41824

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